

Date: Tuesday, 15/07/2008 9:15:28 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING LUG
Job Number :	40492		
Estimate Number :	11535		
P.O. Number :		Part Number :	D30403
This Issue :	15/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3040 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	35976	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JUD 08.15.08	Due Date :	15/08/2008
Comment :	Est: B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev: A Now on Waterjet 07-03-07 JLM		

Qty: 30 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
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Comment: Qty.: 0.3718 f(s)/Unit Total : 11.1542 f(s)
 6061-T6 Bar .178" x 4.0"
 Material: 6061-T6 alum plate 0.188" thick

Batch: 103386 HB 8-8-11

2.0	WATER JET	FLOW WATER JET
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PHD →

Comment: FLOW WATER JET
 1-Cut as per Dwg D3041
 Dwg Rev: B
 Prog Rev: B

HB 8-8-11

32

2-Deburr if necessary 11 8-8-12 JD

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-8-11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counter
 508/00/12 x 300

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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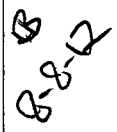



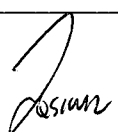
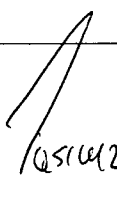
Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: PW

8/8/13

30x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3040-3 PAR #: N/A Fault Category: Prod. FAB. ASS. Mfg. & Svc. NCR: (Yes) No DQA: D Date: 08/08/14
 QA: N/C Closed: D Date: 08/08/14

NCR: <u>40492</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/12	# 2.2	2 Parts have defects found During inspection. 1- has a cut mark from welder jet moving across the Part with pressure left on. RC machine malfunction. 2- has a cut deburring mark about 0.030 on the non welded Side. R.C. Hummer error	 10/11/12	Scrap & destroy No replace.	 8-8-12	S 08/08/12	 10/11/12	S 8/6/12
			 10/11/12			S 8/6/12	 10/11/12	S 8/6/12
			 10/11/12			S 8/6/12	 10/11/12	S 8/6/12

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:29 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 40492

Part Number: D30403

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



30

Comment: FINAL INSPECTION/W/O RELEASE

D 08/08/14

Job Completion



u 08.08.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

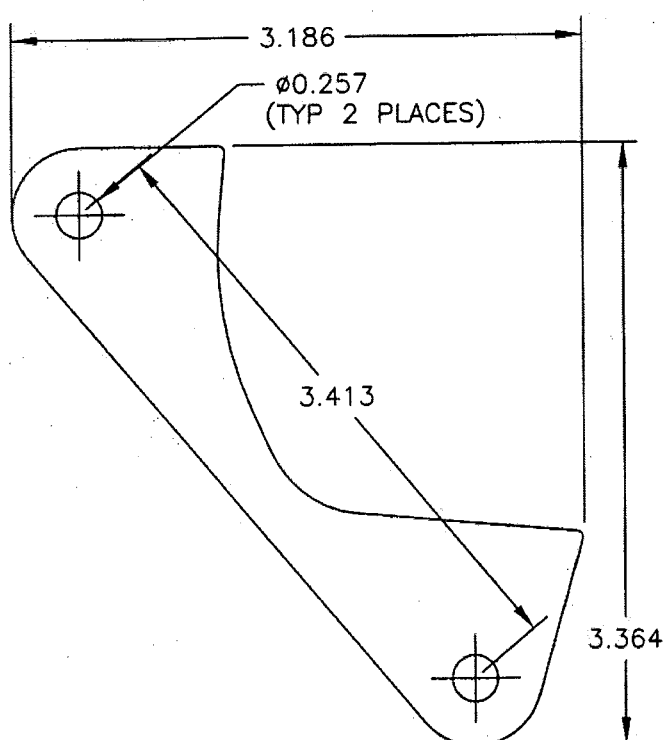
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

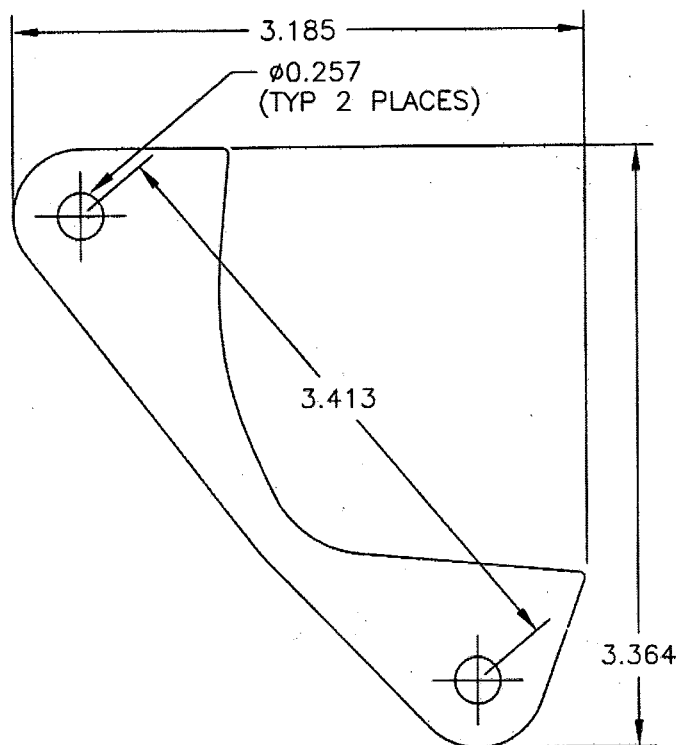


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
				D3040	SHEET 1 OF 1
DATE		TITLE		SCALE	
01.09.04		MOUNTING LUG		1:1	
A		01.06.27		NEW ISSUE	
B		01.09.04		CHANGED PROFILE 5 DEGREES	

RELEASED
01.09.07



D3040-1



D3040-3

NOTES

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK (REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40492

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